

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017969**Date Inspected:** 28-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment and Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 007139

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK005A7-001-236

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint W5-SB1-051-082 ~087 located on OBG steel barrier. ZPMC welder is identified as 070217. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB1-051-100 ~105 located on OBG steel barrier. ZPMC Welder is identified as 070217. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC

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appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint W5-SB1D-010-075 ~078 located on OBG steel barrier. ZPMC Welder is identified as 068858. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB1D-010-063 ~074 located on OBG steel barrier. Welder is identified as 068858. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint W5-SB1-047-075 ~078 located on OBG steel barrier. ZPMC Welder is identified as 066751. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB1-047-116~121 located on OBG steel barrier. Welder is identified as 066751. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on steel barrier of OBG Component W5- SB13A-001 and W5- SB13-002, 001

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on steel barrier of OBG Component W5- SB58-001 and W5- SB58-001.

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A8-009-002 and 007 located on OBG of Bike Path. ZPMC Welder is identified as 062786. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK004A8-009-001 and 130 located on OBG of Bike Path. ZPMC Welder is identified as 062786. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A1-002-006 and 005 located on sole plate of OBG of Bike Path. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint BK004A1-002-008 and 038 located on sole plate of OBG of Bike Path. ZPMC Welder is identified as 062739. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

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FCAW welding of weld joint BK004A1-007-013 and 021 located on sole plate of OBG of Bike Path. ZPMC Welder is identified as 062734. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW plug welding of weld joint BK004A2-009-017 and 019 located on bottom cover plate of OBG of Bike Path. ZPMC Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132-2-Plug.

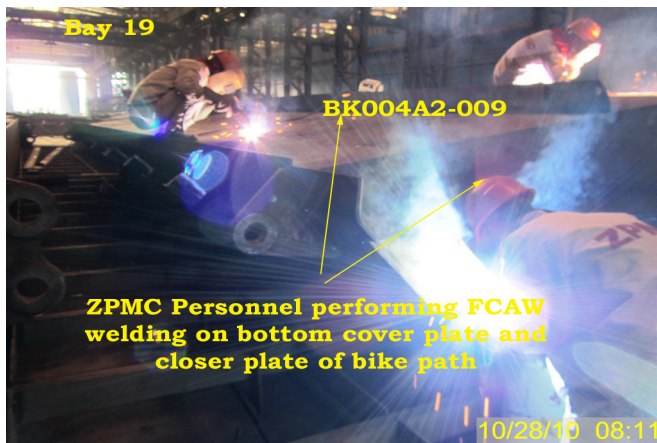
Visual Inspection after Blast

OBG Cross Beam 14

This QA Inspector performed a preliminary random visual inspection on OBG CB 14, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached pictures.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on OBG Component steel barriers.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer